

Memo

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 71399

Thursday, June 30, 2011 3:19:32 PM

Page 2

Item ID: D4422-1

Accept

Setup Start

Revision ID: PRELIM

Stop

Item Name: Shim

Start Date: 6/30/2011 Start Qty: 7.00

Cust Item ID:

Required Date: 7/8/2011 Req'd Qty: 7.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan /
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

11/17/05

MF
11-02-05

POSITIVE RECALL

EFFECTIVE 11/07/05 AUTH KLRELEASED 11/07/05 DATE 11.07.05

OK TO PACKAGE

W/DSI 9562-01 B/W 71397

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, June 30, 2011 3:19:37 PM

Page 1

Work Order ID: 71399



Parent Item: D4422-1



Parent Item Name: Shim

Start Date: 6/30/2011

Required Date: 7/8/2011

Start Qty: 7.00

Required Qty: 7.00

Comments: IPP revA 11.06.30 new issue ec verified by: JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M6061T6S.125

Purchased

No

sf

92.0000

0.118632



6061-T6 .125 Sheet

Handwritten signature and date: 5/11/07/04

Location

Loc Qty

Loc Code

MAT021

92

113608

84.5

116700

7.5

0.118632

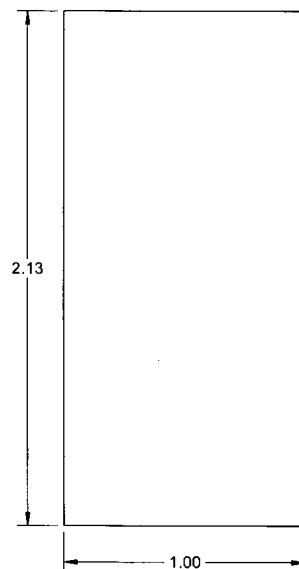
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

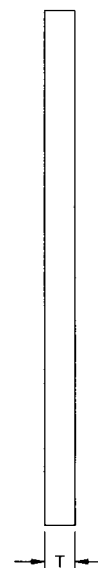
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D4422-X SHIM



P/N	"T" THICKNESS
D4422-1	0.125
D4422-3	0.063

W/O 71399

PRELIMINARY ISSUE

11.06.22

NOTES:

1) MATERIAL:

D4422-1: 6061-T6/T62 ALUMINUM SHEET, 0.125 THICK, PER QQ-A-250/11
OR AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.125

OR
6061-T6/T651/T6510/T6511/T62, 0.125 X 1.000, PER QQ-A-225/8
OR AMS-QQ-225/8 (OR AMS 4117/4128/4115/4116) OR QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B

D4422-3: 6061-T6/T62 ALUMINUM SHEET, 0.063 THICK, PER QQ-A-250/11
OR AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.063

OR
6061-T6/T651/T6510/T6511/T62, 0.063 X 1.000, PER QQ-A-225/8
OR AMS-QQ-225/8 (OR AMS 4117/4128/4115/4116) OR QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4422-X" AND B/N PER QSI 044 6.1

7) WEIGHT: D4422-1 = 0.01 lbs; D4422-3 = 0.01 lbs

PA1	NEW ISSUE	MB	11.06.22
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.06.22		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4422** REV. PA1
SHEET 1 OF 1

TITLE **SHIM** SCALE
NTS

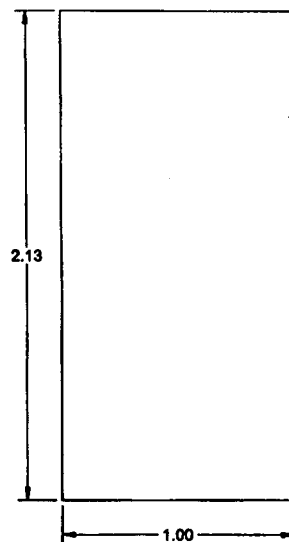
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DART AEROSPACE LTD		Work Order:	B 71399
Description: Shm		Part Number:	D422-1
Inspection Dwg: D422 Rev: PA		Page 1 of 1	

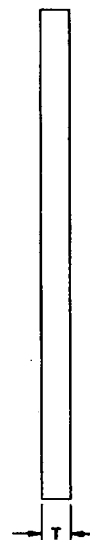
☒ First Article ☐ Prototype

[illegible]

Measured by: <i>E/S</i>	Audited by: <i>S</i>	Prototype Approval:	N/A	
Date: <i>11/07/04</i>	Date: <i>11/07/04</i>	Date:	N/A	
<div> <div>Rev</div> <div>Date</div> <div>Change</div> </div> <i>to Prot Day only</i>		Revised by	Approved	
A		New Issue	KJ/JLM	



D4422-X SHIM



P/N	THICKNESS
D4422-1	0.125
D4422-3	0.063

71399

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OR

6061-T6/T651/T6510/T6511/T62, 0.125 X 1.000, PER QQ-A-225/8
OR AMS-QQ-225/8 (OR AMS 4117/4128/4115/4116) OR QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
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D4422-3: 6061-T6/T62 ALUMINUM SHEET, 0.063 THICK, PER QQ-A-250/11
OR AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M8061T6S.063

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RELEASED
2011-07-06

A		NEW ISSUE		MB	11.06.22
REV.		DESCRIPTION		BY	DATE
DESIGN	1	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4422 TITLE SHIM		REV. A	
DRAWN	1			SHEET 1 OF 1	
CHECKED	1			SCALE	
MFG. APPR.	1			NTS	
APPROVED	1				
DE APPR.	1				
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